

Work Order ID 58972

Thursday, May 20, 2010 12:37:12 PM



Page 1

Item ID: D2435

Accept



Setup Start



Revision ID:

Item Name: Bearpaw, 206

Stop



Start Date: 5/20/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: ✓Date: 10-5-20

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B10-6-7

(4)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

aml / 8/10/2009

4

1

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

aml / 8/10/2009

4

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 02435 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: _____ Date: 10/06/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/06/14

NCR: <u>58972</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/06/09</u>	<u>130</u>	<u>1 part scrap - Part was under tolerance & damaged on along 1 side, from the tool. FAI was filled out as good & C: LOA</u>	<u>[Signature]</u> <u>05/14/12</u>	<u>Scrap.</u> <u>replace 1 Qty: 1</u> <u>Batch: 114624</u>	<u>[Signature]</u> <u>10-06-10</u>	<u>[Signature]</u> <u>10/06/10</u>	<u>[Signature]</u> <u>05/14/12</u>	<u>[Signature]</u> <u>10/06/10</u>

NOTE: Date & initial all entries

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Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 5/20/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00

MMZ
10/06/10

4

1



QC

Memo

Quality Control

151

Identify as per dwg & Stock Location: PPP

0.00



Packaging

Memo

Packaging

B58871 4X

m-1 10/06/11

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/06/14 JH

C2101611

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58972



Parent Item: D2435



Parent Item Name: Bearpaw, 206



Start Date: 5/20/2010

Required Date: 5/31/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	430.0000	3.2	12.8		
											B10-6-7	

Location

Loc Qty

Loc Code

MAT

430

112186

22

113903

88

114624

320

114624

④

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	58972
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓			
B	5.500	+/-0.030	5.508	✓			
C	0.200	+/-0.030	.128	✓			
D	R0.250	+/-0.030	.250	✓			
E	0.250	+/-0.010	.243	✓			
F	0.625	+/-0.030	.621	✓			
G	0.25 x 45°	+/-0.030	.25	✓			
H	0.375	+/-0.010	.375	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.950	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.937	✓			
M	0.30	+0.030/-0.000	.323	✓			
N	0.375	+/-0.030	.380	✓			
O	7.375	+/-0.030	7.375	✓			
P	4.250	+/-0.010	4.25	✓			
Q	2.000	+/-0.030	2.000	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.75	✓			

Measured by:	LS
Date:	10/26/09

Audited by:	MM
Date:	10/26/10

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	✱

W/O:		WORK ORDER CHANGES					
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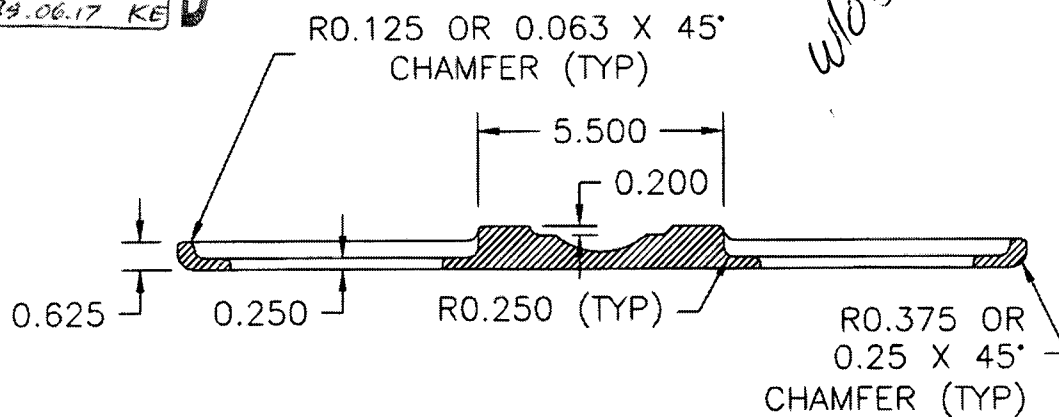
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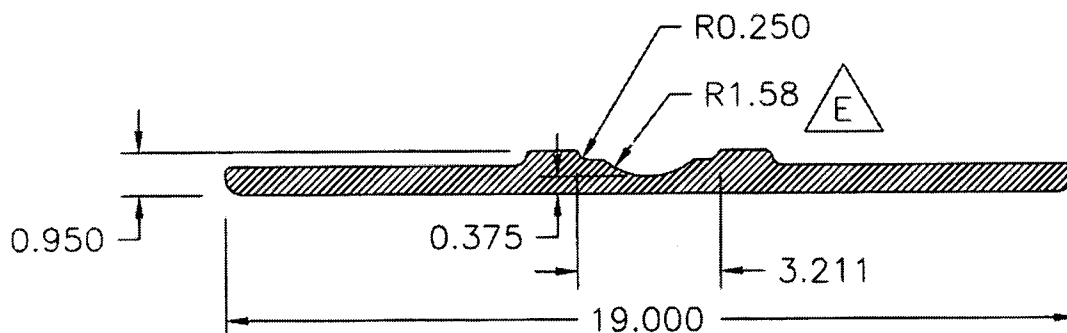


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>MB</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

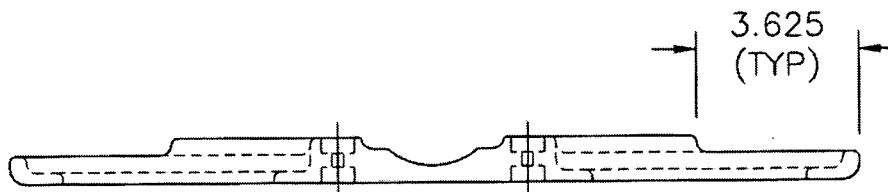
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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